

Work Order ID 82136

82136

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March-23-12 10:47:36 AM

Item ID: D2150 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Packer Doubler, Hinge
 Start Date: 23/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 06/04/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2150	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2150 Dwg Rev: A Prog Rev: 1 2-
 2024 0.040 Deburr if necessary
 (24) MLJ/Jm
 12-4-14

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
 (24) MLJ/Jm
 12-4-14

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
 (24) MLJ/Jm
 12-4-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:10								
	FINISH TIME: 2:40								

m121134

32001

2:40

24X 12-4-16

24X 12/04/17

W/O:		WORK ORDER CHANGES					
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N900040100

Setup Start *NS1*

Stop ***NS2***

24

24

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

160

0.00

24 of BL 14-17.

Identify as per dwg & Stock Location: SI 5 0.00

170

0.00

24x

12-2-18.

QC21- Final Inspection - Work Order Release	0.00
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180

0.00

Quality Control

12/4/19 *[Signature]*

R12-04-18

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Picklist Print

March-23-12 10:47:41 AM

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Work Order ID: 82136

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Parent Item: D2150

D2150

Parent Item Name: Packer Doubler, Hinge

Start Date: 23/03/2012

Required Date: 06/04/2012

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP C00.11.27Re-format (mpp 2101)EC

IPP Rev:D 06-08-23 Now on Waterjet

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	191.1584	0.025	0.631579			

M2024T3S 040

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

191.158421

117684

21.318421

120196

59.41

120605

110.43

120605

mlh/asm
12-4-14

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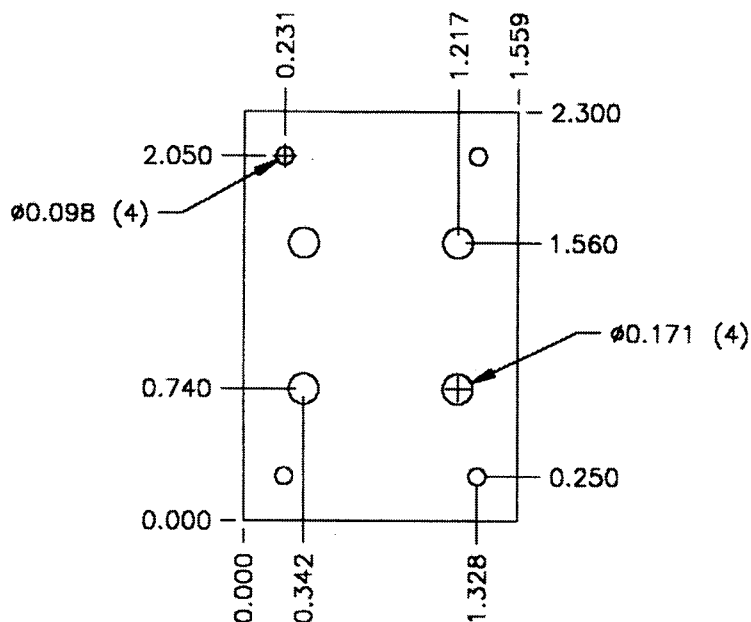
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	PACKER	SCALE
95:05:01			1:1

RELEASED
96/06/13 BWS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82136 MLT
12/03/23

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

W/O:		WORK ORDER CHANGES					
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